Page 1

Work Order ID 62124 Thursday, September 16, 2010 10:14:44 AM PB67-43001-257 Item ID: **Revision ID:** Inner Tube Item Name: **Start Date:** 9/16/2010 Start Qty: 1.00 **Required Date:** 10/22/2010 Req'd Qty: 1.00 Reference: Process Plan: MF Approvals: QC: Sequence ID/ Operation

Accept

Setup Start Stop

Cust Item ID: Customer:

Date: 10-9-76 Tooling:

Date: _____

Date: Date: Run Start

Stop

Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Qty Qty Number Stamp Code

SPC (Y/N):

Draw Nbr **Revision Nbr** B67-43001 C

100

Small Fab

Small Fab

Small Fab

Memo

1- cut to length as per dwg

0.00

0.00

2- deburr

110



Quality Control

QC5- Inspect part completeness to step on W/O

Memo

5× 10/09/25

120



Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1- drill hole as per dwg

2- deburr

0.00

Dart Aerospace Ltd

N/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	PROCEDURE CHANGE						Approval QC Inspector					
							<u> </u>							
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A :							
	Resolution:			ion:	_ QA: N/C C	losed:	·	Date: _						
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	R)								
DATE	STEP	Description of NC Section A	Initial	Action Description	ion B Sign	& Secti	cation	Approval Chief Eng	Approval QC Inspector					
			Chief Eng	Chief Eng	Date									
		**												

Thursdav. September 16, 2010 10:14:44 AM Item ID:

Required Date: 10/22/2010

PB67-43001-257

Accept

Setup Start



Revision ID:

Item Name:

Inner Tube

9/16/2010

Start Oty: 1.00

Rea'd Otv: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan: Date: Tooling:

Date:

Run

Start

Stop

Stop

QC: Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

130

OC

Ouality Control

Operation Description

OC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool # Plan Code

Accept Qty

Reject

Reject Insp.

Qty Number Stamp

Memo

0.00

140

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

(1) 10/2/27 (1)

10/09/27 X

Dart Aerospace	Ltd	
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Dart Ae	rospace	e Ltd												
W/O:		WORK ORDER CHANGES												
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQA	\:	Date: _					
						QA: N/C Closed: Date:								
NCR:		V	VORK ORD	ER NON-CONFO	RMANC	E (NCR)							
DATE	CTED	Description of NC			Section B		Verific	ation	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign & Section			Chief Eng	QC Inspector				
								٠						

Picklist Print

Thursday, September 16, 2010 10:14:44 AM

Work Order ID: 62124

PB67-43001-257

Parent Item Name: Inner Tube





Start Date: 9/16/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

Parent Item:

IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.250W.125		Purchased	No			100	f	32.5830	3.46	3.642105			
			 										

ALUM. RD TUBING 1.250 x.125W

Location	Loc Qty	Loc Code
MAT	24	
114467	24	
MAT016	8.583	
109850	4	
110680	4.583	

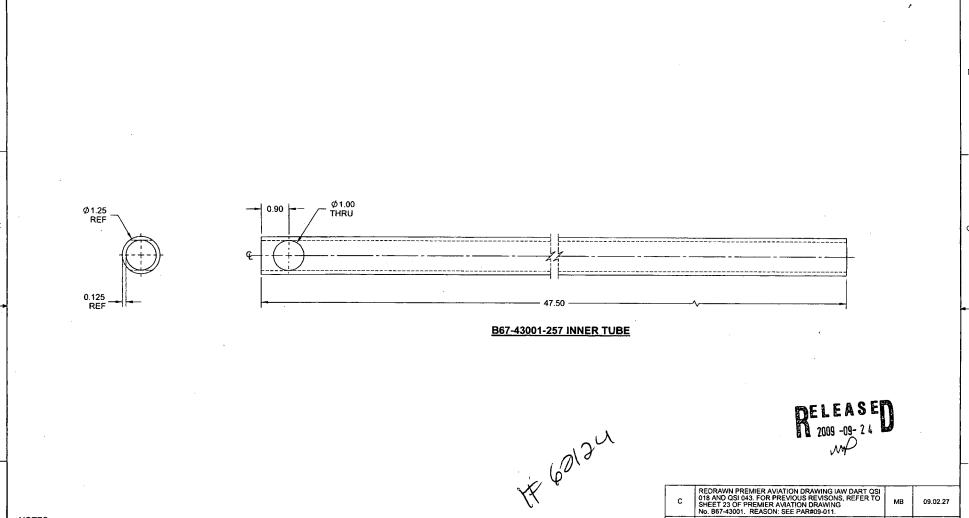
4 Rt 5/2 10/09/25

Dart Aeı	rospace	e Ltd								
W/O:			W	ORK ORDER CHANGE	S					
DATE	STEP	PRC	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	• •	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _			
	R	esolution:	Dispositio	n:	QA: N/C CIG	sed:	Date:			
NCR:			WORK ORD	ER NON-CONFORMAN	NCE (NCR) .				
D.4.T.F.	0770	Description of NC		Corrective Action Section		Verificat	ion Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	, , ,	QC Inspector		
					·					

DART AEROS	PACE LTD			1	Work Order:	62124			
Description:	Annel Tab				Part Number:	BR67-43001-257			
Inspection Dwg:	Rev:					Page 1 of 1			
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST				
	X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
01.25	±-010	\$1.25			Qe1-	81-9			
-125	- -010	125							
-70	=-030	-90							
0/1.00	4,030	@ 799							
47.50	× 030)	42,50			1-20	51-1			
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Measured by:	18	Audited by:	\mathcal{L}	Prototype Approval:	N/A
Date:		Date:	10/07/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR AMS-QQ-A-220/8 OR AMS-QQ-A-225/8 REF. DART SPEC. M6061T6T1.250W.125

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.02 lbs

С	018 AN	D QSI 0 23 OF F	43. FOR	AVIATION DRAWING IAW DART QSI PREVIOUS REVISONS, REFER TO R AVIATION DRAWING DN: SEE PAR#09-011.	МВ	09.02.27		
REV.			, 1	DESCRIPTION	BY	DATE		
DESIGN RW			W	DART AEROSPA	CEL	TD		
DRAWN			J.	HAWKESBURY, ONTARIO, CANADA				
CHECK	ED	74.	35/	DRAWING NO.		REV. C		
MFG. A	PPR.	Ch	//	B67-43001-257		SHEET 1 OF 1		
APPRO	VED	3	TITLE			SCALE		
DE APPR.		N	/A	INNER TUBE		NTS		
DATE 09.02.27				COPYRIGHT ⊕ 1995 BY DART AEROSPACE LTD THIS DOCUMENT REPROVATE AND COMPRIDENTIAL AND IS SUPPLED ON THE EXPRESS CONTROL THAT IT IS NOT TO BE USED FOR ANY PROSESS ON CORPOR OF COMMUNICATION TO MAY OTHER PERSON WITHOUT				

Dart Aerospace Ltd

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W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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		. }												
Part No: PAR		PAR #:	Fault Cate	gory:	_ NCR: Ye	s No DO	QA:	Date: _						
	R	esolution:	Dispositio	າ:	QA: N/C	Closed: _		Date: _						
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)								
		Corrective Action			Section B			Annexal	Ammuoval					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng			fication otion C	Approval Chief Eng	Approval QC Inspector					
									3					
									1					